

Date: Tuesday, 5/23/2006 8:31:25 AM  
User: Kim Johnston

## Process Sheet

*Split* 06/05/25

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET		
Job Number	27188				
Estimate Number	10364				
P.O. Number	N/A				
This Issue	5/23/2006	S.O. No.	: N/A		
Prsht Rev.	NC				
First Issue	N/A	Type	: SMALL /MED FAB		
Previous Run	25924				
Written By	<i>SB</i> COMMENT Below				
Checked & Approved By	<i>SB</i> 06.05.23				
Comment	: Est: A 01.08.27 New issue SM/EC			Qty:	16 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D30461	Lug Bracket		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) LUG BRACKET		
		Qty Part Number Description Batch		
		1 D3046-1 Lug Bracket B 24715		
2.0	D30463	Lug Bracket		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) LUG BRACKET		
		Pick:		
		Qty Part Number Description Batch		
		1 D3046-3 ( Bell P/N: 206-052-106-1) Lug Bracket N/A		
		Return Authorization #	B 26224	① B 27197
		Bell original batch#	487	See w/o
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1		
		1- Tranfer drill holes from D3046-3 into D3046-1 as per Dwg D3046		
		2- Counter sink inside holes of D3046-1 as per Dwg D3046		
		3- Deburr		
4.0	QC5	INSPECT WORK TO CURRENT STEP		
		Comment: INSPECT WORK TO CURRENT STEP		
		<i>N/A</i> 06/05/25		

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27188

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 POWDER COATING



POWDER COATING

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

N/A QM 06/05/25

6.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7.0 MS20426AD57



Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 160.0000 Each(s)

Rivet

Qty Part Number

10 MS20426AD5-7

Description

Batch

M 3676

SB

06/05/25

(4)

8.0 SMALL FAB 1



SMALL &amp; MEDIUM FAB RESOURCE 1



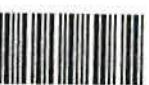
Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3046

SB 06/05/25

(4)

9.0 QC5



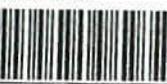
INSPECT WORK TO CURRENT STEP



(4)

Comment: INSPECT WORK TO CURRENT STEP

10.0 POWDER COATING



POWDER COATING



(4)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DL 06/05/26

(4)

11.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



(4)

Comment: INSPECT POWDER COAT

12.0 PACKAGING 1



PACKAGING RESOURCE #1



(4)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PL 06/05/26  
4

Tuesday, 5/23/2006 8:31:25 AM

Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27188

Part Number: D3046041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

 06/05/26 

Job Completion



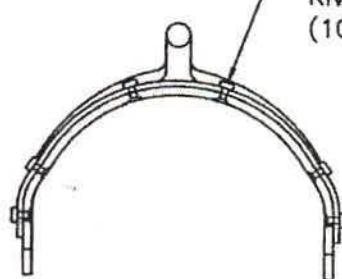
1706103124

COPY  
BY  
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
		REV. A
DATE	DRAWING NO.	SHEET 1 OF 2
01.08.23	D3046	SCALE
A	TITLE	1:2
01.08.23	LUG BRACKET	
	NEW ISSUE	

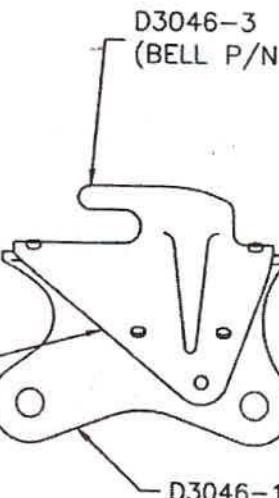
RELEASED

a.08-27



TRANSFER DRILL  $\phi$ 0.156 HOLES  
FROM D3046-3 TO D3046-1.  
C'SINK  $\phi$ 0.286 x 100°  
D3046-1 INSIDE BORE.  
ASSEMBLE USING MS20426AD5-7  
RIVETS.  
(10 PLACES)

CENTER D3046-3  
ON D3046-1



D3046-1

D3046-041 LUG BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.  
RE-POWDER AFTER ASSEMBLY.
- REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27188